

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LONG PIN BRACKET
Job Number	: 35483		
Estimate Number	: 11204		
P.O. Number	: N/A	Part Number	: D333011
This Issue	: 10/31/2007 S.O. No. : N/A	Drawing Number	: D3330 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: N/A	Material	: N/A
Written By	: _____	Due Date	: 11/16/2007
Checked & Approved By	: _____	Qty:	10
Comment	: Est. A 06.01.13 New issue KJ/JLM est b 07.05.14 rev c dwg ec	Um:	Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

10	M1010B2500X01000	1010-1025 Steel Bar
----	------------------	---------------------

Comment: Qty.: 0.2734 f(s)/Unit Total : 1.6405 f(s)

1010-1025 Steel Bar

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel/

M1010-B2.500x01.000)

Identify for D3330-11

Batch: M106317

2.0 BAND SAW BAND SAW

Comment: BAND SAW

Cut blanks: 2.500" x 1.000" x ~~3.00"~~ long (+/-0.030)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA479 and Dwg D3330

Identify as D3330-11

Deburr

40 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK

Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/11/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/31/2007 3:26:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG PIN BRACKET

Job Number: 35483

Part Number: D333011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



X10

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CARL W523

Pl 07.11.26

7.0

QC21

FINAL INSPECTION/W/O RELEASE



10

Comment: FINAL INSPECTION/W/O RELEASE

Pl 07.11.26

Job Completion



u 07.11.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 35483
Description: Long Pin Bracket		Part Number: D3330-11
Inspection Dwg: D3330 Rev: C		Page 1 of 1


FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	+/-0.030	5.008	✓			
4.625	+/-0.010	4.628	✓			
0.260	+/-0.010	.258	✓			
Ø0.594	+0.005/-0.000	.594	✓			
0.875	+/-0.010	.875	✓			
0.838	+/-0.010	.840	✓			Perm. chg.
0.700	+/-0.010	.700	✓			
0.500	+/-0.010	.508	✓			
2.25	+/-0.030	2.252	✓			
0.950	+/-0.010	.952	✓			
Ø0.531	+0.005/-0.000	.535	✓			
Ø0.348	+0.005/-0.000	.350	✓			
Ø0.516	+0.005/-0.000	.518	✓			
0.467	+/-0.010	.459	✓			
1.250	+/-0.010	1.250	✓			
1.00	+/-0.030	.996	✓			
0.10 x 45°	+/-0.5°	.091 x 45°	✓			

Measured by: J.L	Audited by: J.F	Prototype Approval:	N/A
Date: 07/11/23	Date: 07/11/23	Date:	N/A

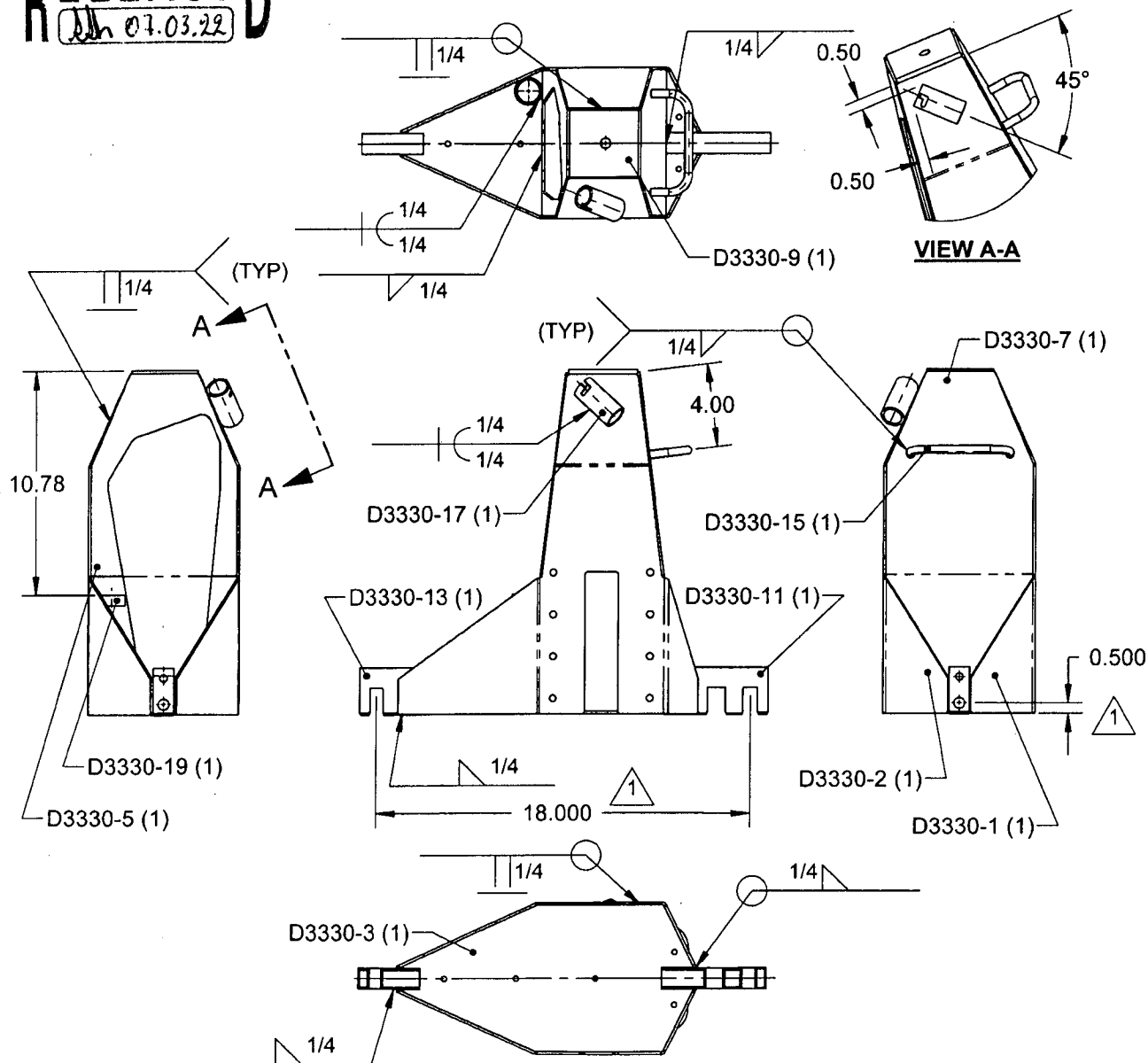
Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.16	Dwg Rev updated	KJ/EC	


 760
 798
 538



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DATE 07.03.20	TITLE FRAME WELDMENT		SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/-2 BY 0.125	

RELEASED
[Signature] 07.03.22



D3330-041 FRAME WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

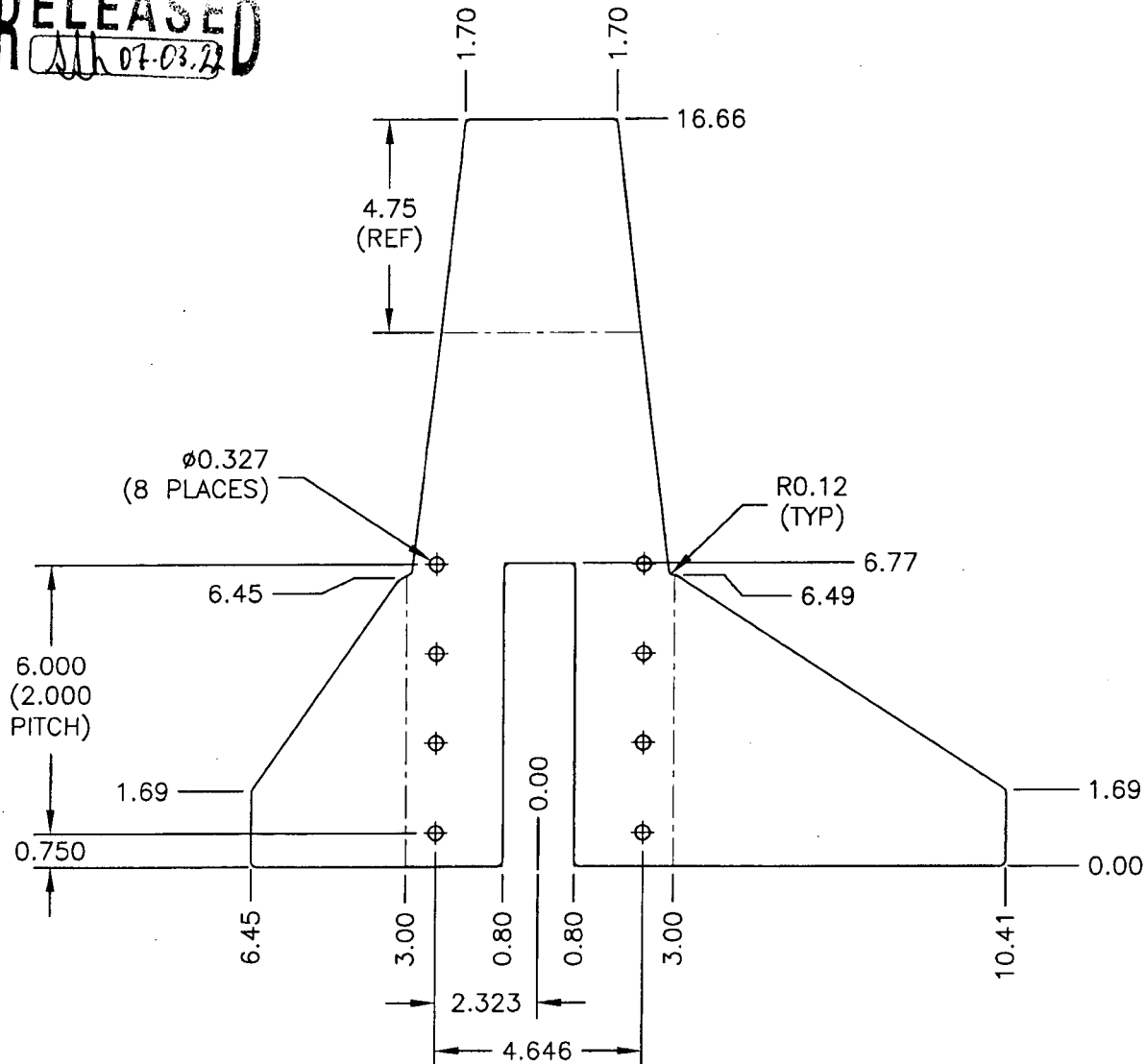
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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
[Signature] 07-03-20**D3330-1 PANEL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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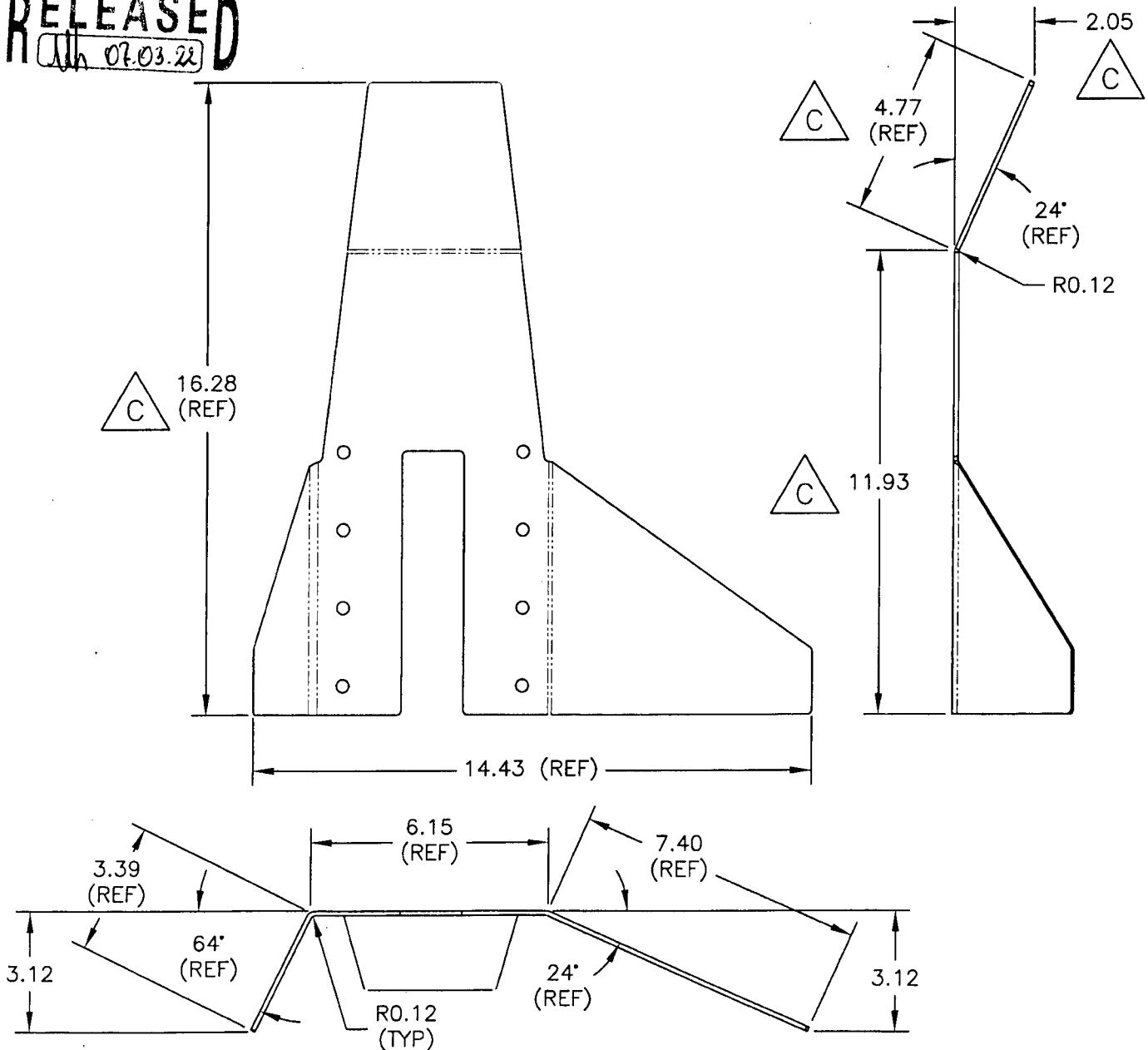
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DATE 07.03.20	TITLE FRAME WELDMENT		SCALE 1:4

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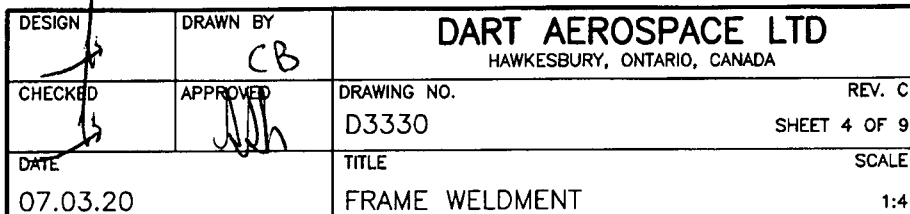


D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

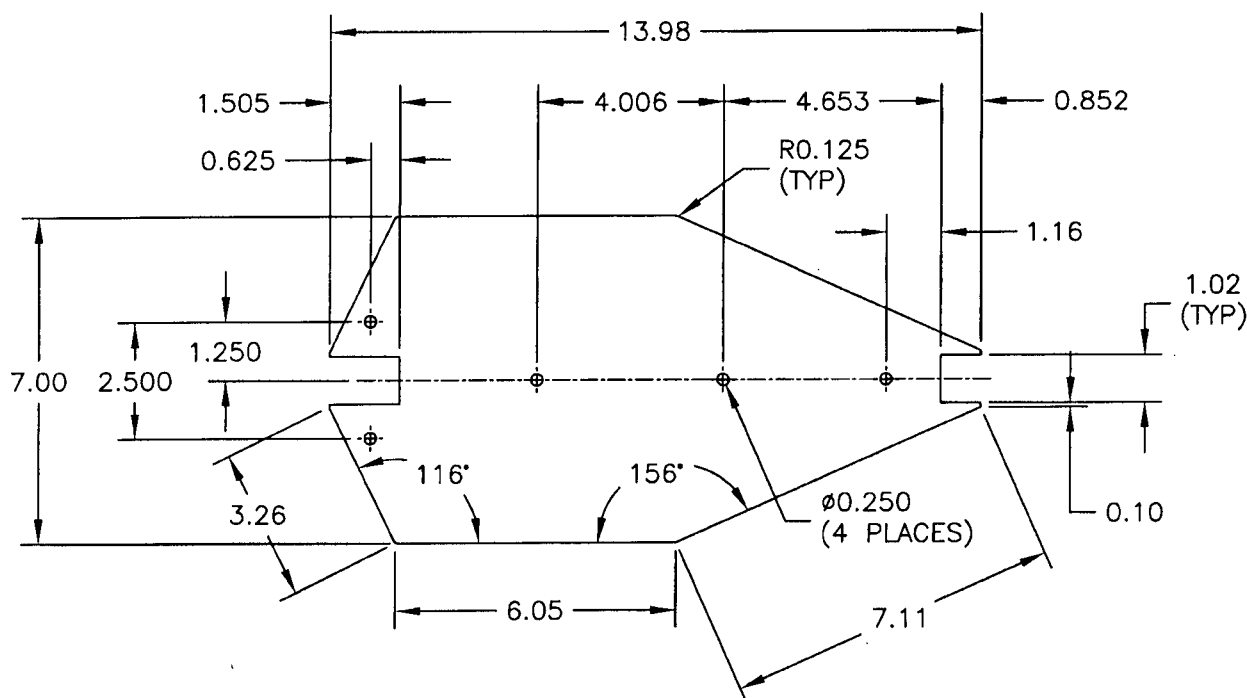
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JUL 07 03 24



D3330-3 PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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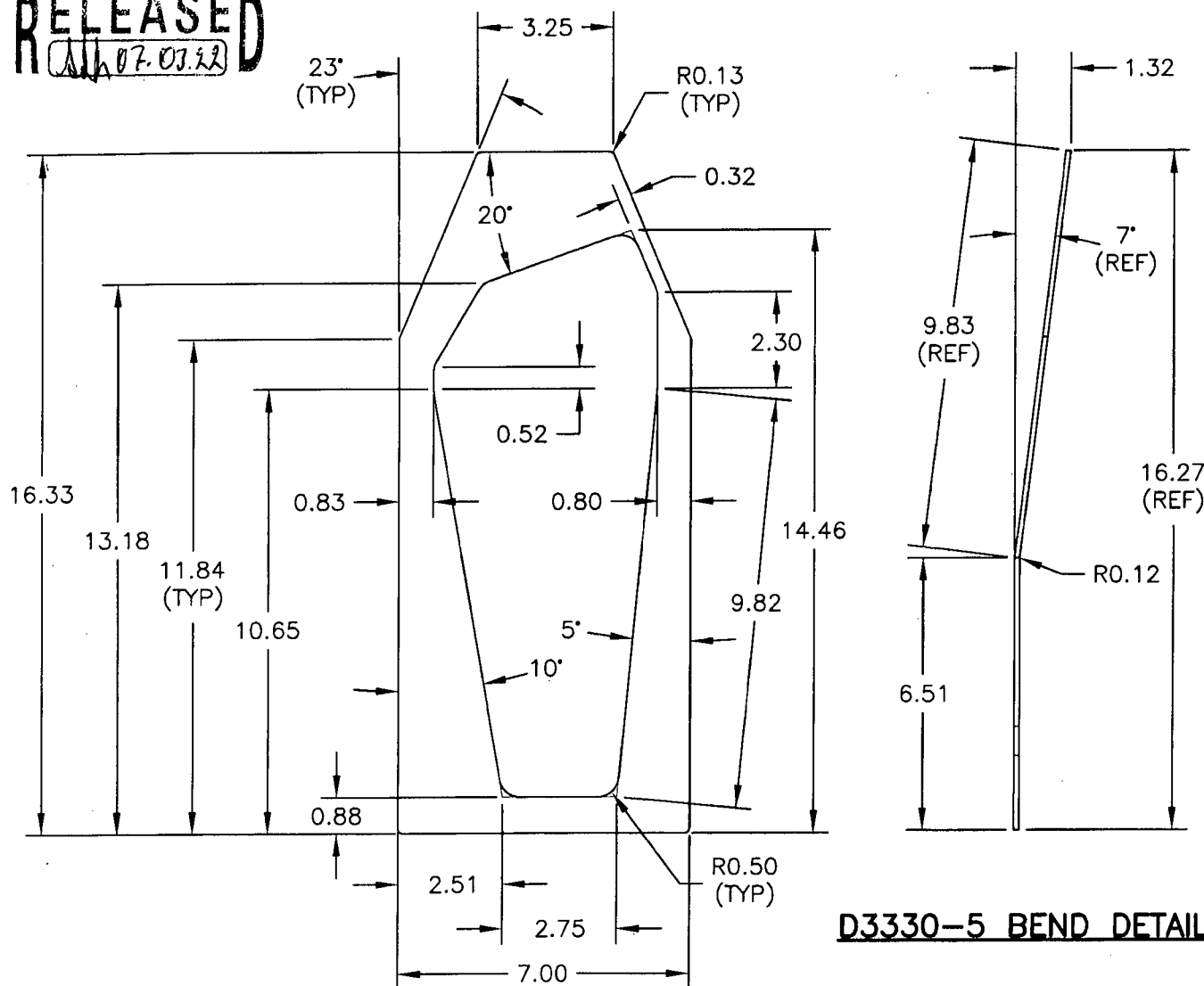
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D3330-5 BEND DETAIL

FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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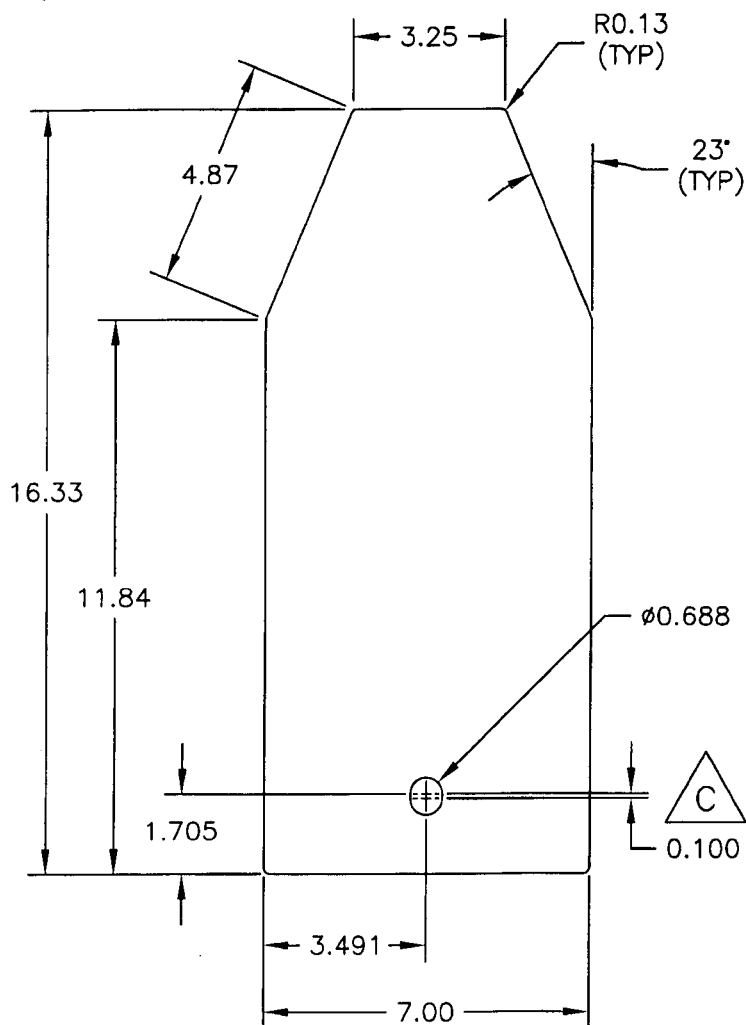
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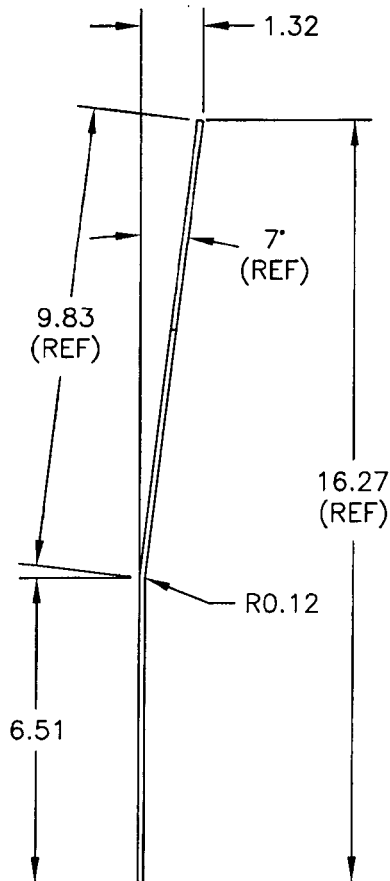


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FLAT PATTERN



D3330-7 BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

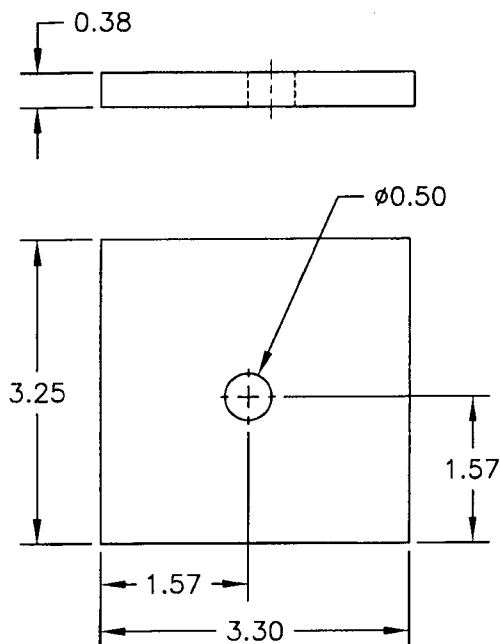
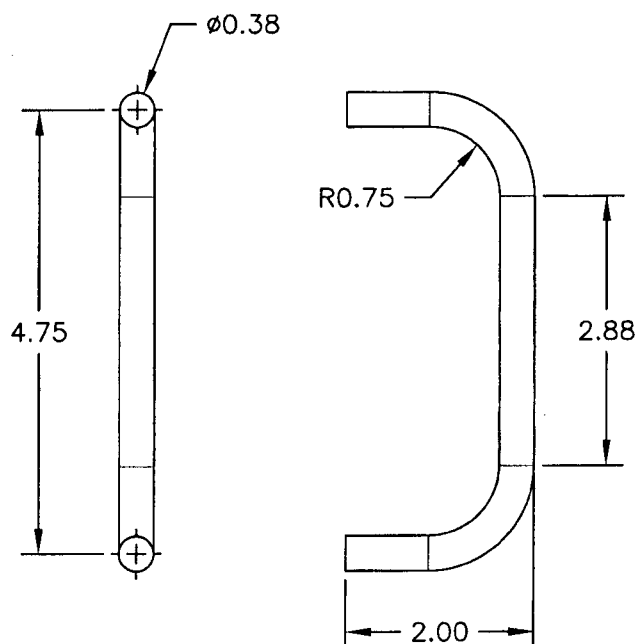
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RELEASED
07.03.22**1 D3330-9 TOP PLATE****2 D3330-15 HANDLE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

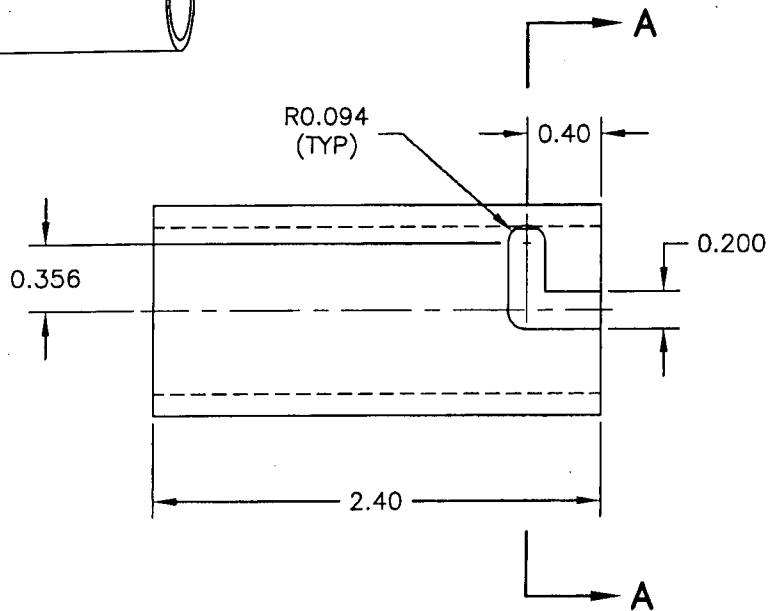
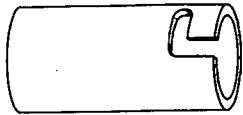
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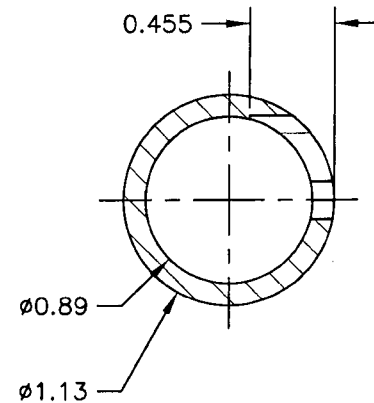
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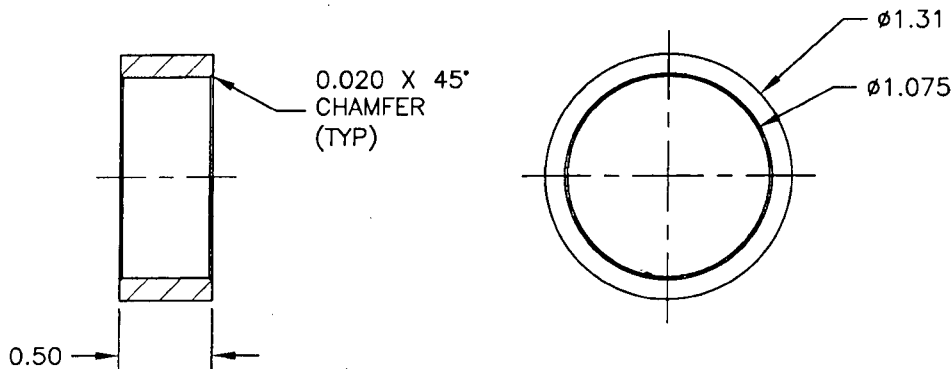


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SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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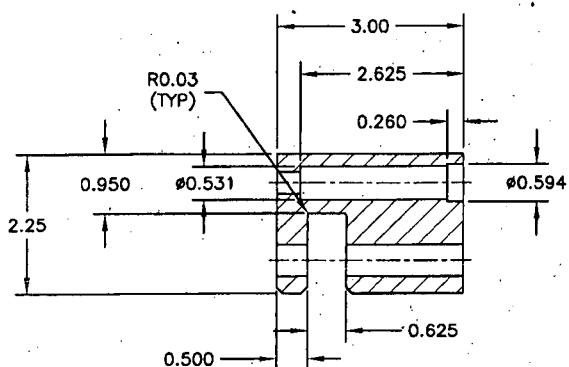
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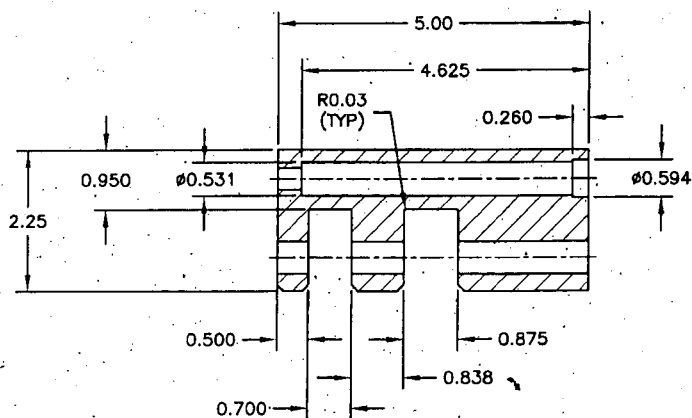
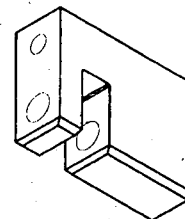
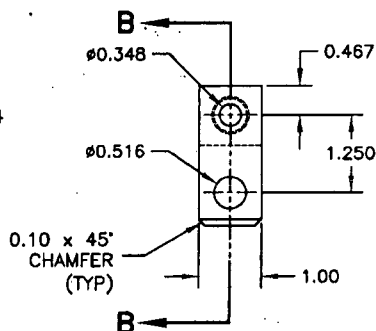
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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:3

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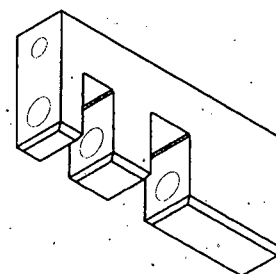
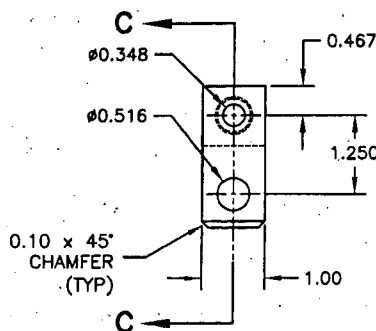
SECTION B-B

D3330-13 SHORT PIN BRACKET



SECTION C-C

D3330-11 LONG PIN BRACKET



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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